

Work Order ID 124242

September-11-14 11:59:45 AM

124242

Page 1

Item ID: D3650-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Panel

Stop

NS2

Start Date: 9/10/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/10/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MJD Date: 14-09-16 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3650	Rev E	E	14.09.16						

100

0.00

DAS

100

FLOW WATER JET

Waterjet

0.00

23

9-09

14-10-22

FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3650 Dwg Rev: E Prog Rev: E 2.
Deburr if necessary

3 0

304.018"

110

QC2- Inspect parts off machine FAI/FAIB 0.00

DAS

110

QC

Memo 0.00

23

9-09

14-10-22

Quality Control

120

QC8- Inspect parts - second check 0.00

DAS

120

QC

Memo 0.00

38

9-09

OCT 22 2014

Quality Control

(3)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design <input type="checkbox"/>											
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Handling/Pre <input type="checkbox"/>											
Material <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Offset/Setup <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Transport <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear			General								
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Cracks <input type="checkbox"/>	Hardware <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>		
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>		
Crushing <input type="checkbox"/>	Contamination <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Misread <input type="checkbox"/>	Inspection Strip in Tube <input type="checkbox"/>	Off-set <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>		
Marks/Chatter <input type="checkbox"/>	Countersink <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>		
								Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>		
								Positioned Wrong <input type="checkbox"/>			
								Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>		

Work Order ID 124242

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Page 2

Item ID: D3650-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Panel

Stop

NS2

Start Date: 9/10/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/10/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130 Brake NC	NC BRAKE Memo Form as per Dwg D3650			DAS 30 9-89		3			14/10/03
140	QC5- Inspect part completeness to step on W/O	0.00							
140 QC Quality Control	Memo	0.00							DAS 38 9-89 NOV 03 2014
150		0.00							
150 Small Fab	Small Fab Memo Assemble as per dwg D3650					3x			14/10/03 DAS 36 9-89

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order ID 124242

September-11-14 11:59:45 AM

124242

Page 3

Item ID: D3650-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Panel

Stop

NS2

Start Date: 9/10/14

Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/10/14

Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(3)			DAS 38 9-89

NOV 04 2014

170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>S1223A</u> Memo	0.00 0.00				(3)			DAS 46 9-89
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NOV 05 2014

180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							14/11/5 28
--	---	--------------	--	--	--	--	--	--	------------

MF
14-11-06

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected <input type="checkbox"/>	Unapproved <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/>	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced		
<input type="checkbox"/>	Centre Not Concentric	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up		
<input type="checkbox"/>	Cracks	<input type="checkbox"/>	Broken/Damage/Defect	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure		
<input type="checkbox"/>	Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld		
<input type="checkbox"/>	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled		
<input type="checkbox"/>	Crushing	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>	Other		
<input type="checkbox"/>	Heat Treat	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>			
<input type="checkbox"/>	Inspection Strip in Tube	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Marks/Chatter	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>			
<input type="checkbox"/>	Wave/Twist in Tube	<input type="checkbox"/>	Fit/Function	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>			

Picklist Print

September-11-14 11:59:44 AM

Page 1

Work Order ID: 124242

124242

Parent Item: D3650-1

D3650-1

Parent Item Name: Aft Panel

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

- IPP Rev:A New Issue 07-09-27 DD verified by: EC
- IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
- IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA Purchased No 150 sf 95.4000 1.583 ****** **(X)** **(6)** DAS
M304S26GA 304/316 0.018 SHEET 23 9-89 14-10-22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

- MAT020 95.4
- 122753 26
- 123135 69.4

MS20427M3-3 Purchased No 130660 150 Each 972.0000 18 ****** **130650** 18 DAS
MS20427M3-3 Rivet 36 9-89 14-11-03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

- GA 12
- 121114 12
- ST312 960
- m129864 960

MS21060-3K Purchased No 150 Each 170.0000 6 ****** **54** 6 DAS
MS21060-3K Nut Plate 36 9-89 14-11-03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

- ST304 170
- m129864 70
- m129913 100

18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____
 Part No. _____
 NCR No. _____

DISPOSITION

Rework
 Scrap
 Use-as-is
 Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Picklist Print

September-11-14 11:59:44 AM

Page 2

Work Order ID: 124242

124242

Parent Item: D3650-1

D3650-1

Parent Item Name: Aft Panel

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

MS21062-3K

Purchased

No

100

Each

60.0000

3

3

**

14/11/03

DAS

36

Nut Plate

MS21062-3K

9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST304	60	
124316	3	
124329	7	
M129913	50	27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____										
NCR No. _____										
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Design <input type="checkbox"/>										
Doc/Data <input type="checkbox"/>										
Equip/Tooling <input type="checkbox"/>										
Handling/Pre <input type="checkbox"/>										
Material <input type="checkbox"/>										
Operator <input type="checkbox"/>										
Offset/Setup <input type="checkbox"/>										
Process <input type="checkbox"/>										
Supplier <input type="checkbox"/>										
Training <input type="checkbox"/>										
Transport <input type="checkbox"/>										
Unapproved <input type="checkbox"/>										
FAULT CATEGORY										
Landing Gear			General							
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>						
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>						
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>							
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>								
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>								
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								
				Other <input type="checkbox"/>						

DART AEROSPACE LTD	Work Order:	124242
Description: Aft Panel	Part Number:	D3650-1
Inspection Dwg: D3650	Rev: E	14.09.16

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

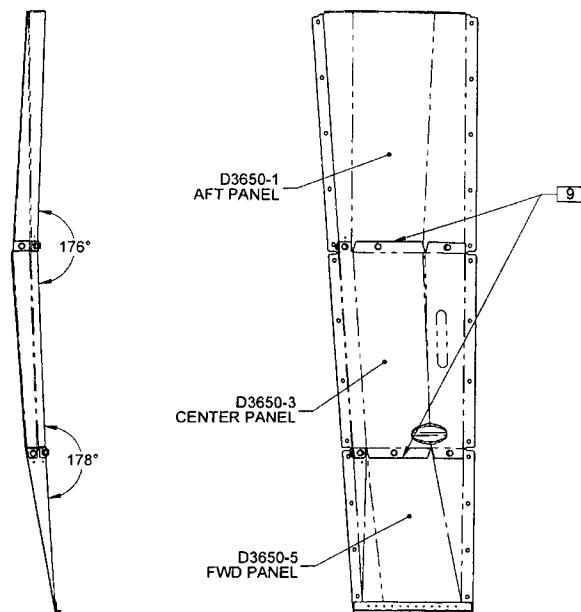
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	-		✓	JLm01
Ø0.213	+0.005/-0.001	0.213"	-		✓	
Ø0.250	+0.005/-0.001	0.252"	-		✓	
0.25	+/-0.030	0.25"	-		✓	
0.344	+/-0.010	0.346"	-		✓	
0.35	+/-0.030	0.35"	-		✓	
0.312	+/-0.010	0.313"	-		✓	
16.611	+/-0.010	16.611"	-		T	JLm07
15.800	+/-0.010	15.800"	-		T	
3.950	+/-0.010	3.950"	-		✓	
2.019	+/-0.010	2.019"	-		✓	
4.026	+/-0.010	4.026"	-		✓	
6.126	+/-0.010	6.126"	-		✓	
8.226	+/-0.010	8.226"	-		✓	JLm08
10.313	+/-0.010	10.313"	-		✓	
12.252	+/-0.010	12.252"	-		T	
17.583	+/-0.010	17.583"	-		T	
16.646	+/-0.010	16.646"	-		T	
2.256	+/-0.010	2.256"	-		✓	
7.183	+/-0.010	7.183"	-		U	
9.551	+/-0.010	9.551"	-		✓	
10.665	+/-0.010	10.665"	-		U	
12.020	+/-0.010	12.020"	-		T	
0.018	+/-0.010	0.018"	-		✓	
					DAS	
					DAS	

Measured by:	23 9-89	Audited by:	38 9-89	Preliminary Approval:	
Date:	14-10-22	Date:	OCT 22 2014	Date:	

Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	
B	09.06.15	Dimensions updated per Dwg Rev C	KJ	
C	12.09.26	Dimensions updated per Dwg Rev D	KJ	

QTY	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

E

D3650-041 TUNNEL TOP PANEL ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.3 lbs
 - 8) TORQUE FASTENERS 15 TO 25 in-lb
 - 9) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

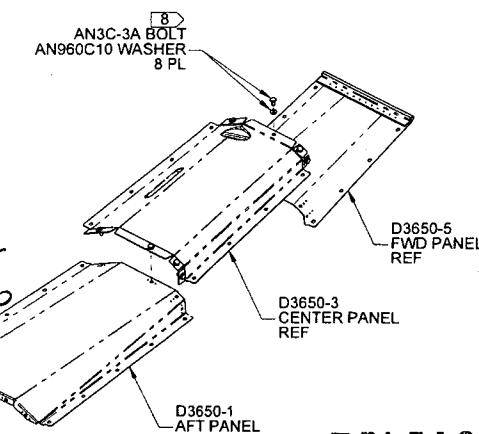
SUBJECT TO AUTOMATIC

WITHOUT NOTICE

WORK ORDER

NO 124242 MLJ

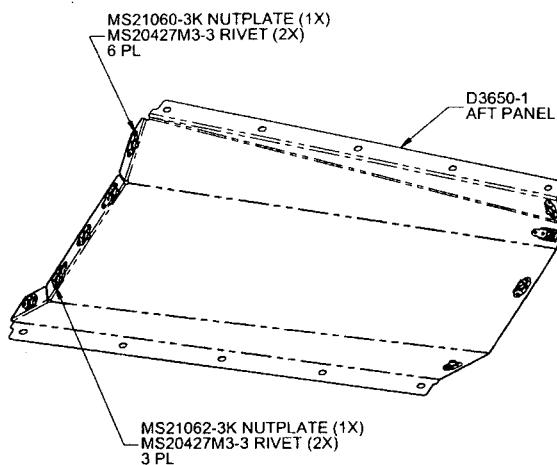
14-09-16



RELEASED
R 2012-10-09
JAN

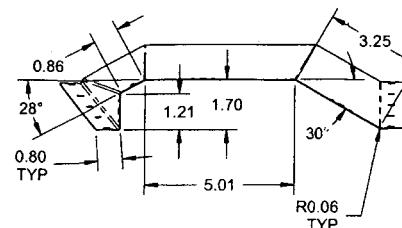
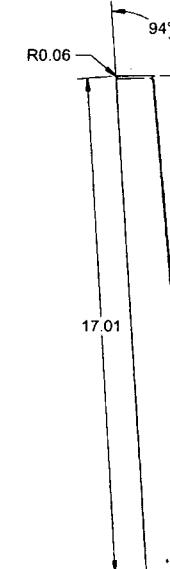
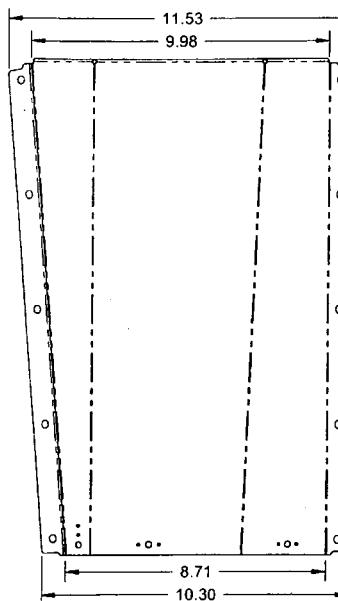
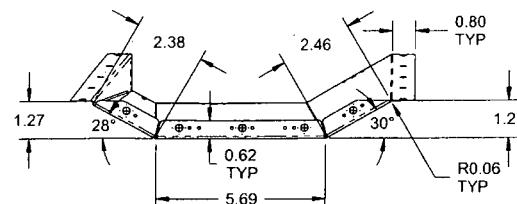
E	REVISED D3650-3: 0.040 IN THICKNESS WAS 0.018. MINOR DIMENSIONAL CHANGES AS A RESULT.	MB	12.10.01
D	D3650-11 REPLACED WITH AN EMBOSSED PAGE 4. DELETED. D3650-3 BEND RELIEFS CHANGED TO TRIANGULAR SHAPE AT BOTH ENDS. D3650-3 HOLES CHANGED TO SLOTS. ALL NOTES UPDATED TO CONFORM TO QSI 043. TIGHTENED CUT TOLERANCES IN ALL FLAT PATTERNS. DEO D3650-11	RP	12.08.12
C	REFORMATTED TO NEW STANDARDS; RELOCATED PART LIST (ZN D2-2); ADDED SECTION VIEW J-1 & REVISE DIMENSIONS (ZN B7-5, C4-9); ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6) MS20615-4M5 WAS CR3523-4-03 & NAS1149C/N432R WAS AN960C4 (ZN D5-7, B5-7; B8-7)	RF	08.10.14
B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEET'S 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11-11F FROM SHEET 6; UPDATED DIMS OF D3650-11-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3650	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOP PANEL ASSEMBLY	NTS
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QTY	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUTPLATE



D3650-1 AFT PANEL

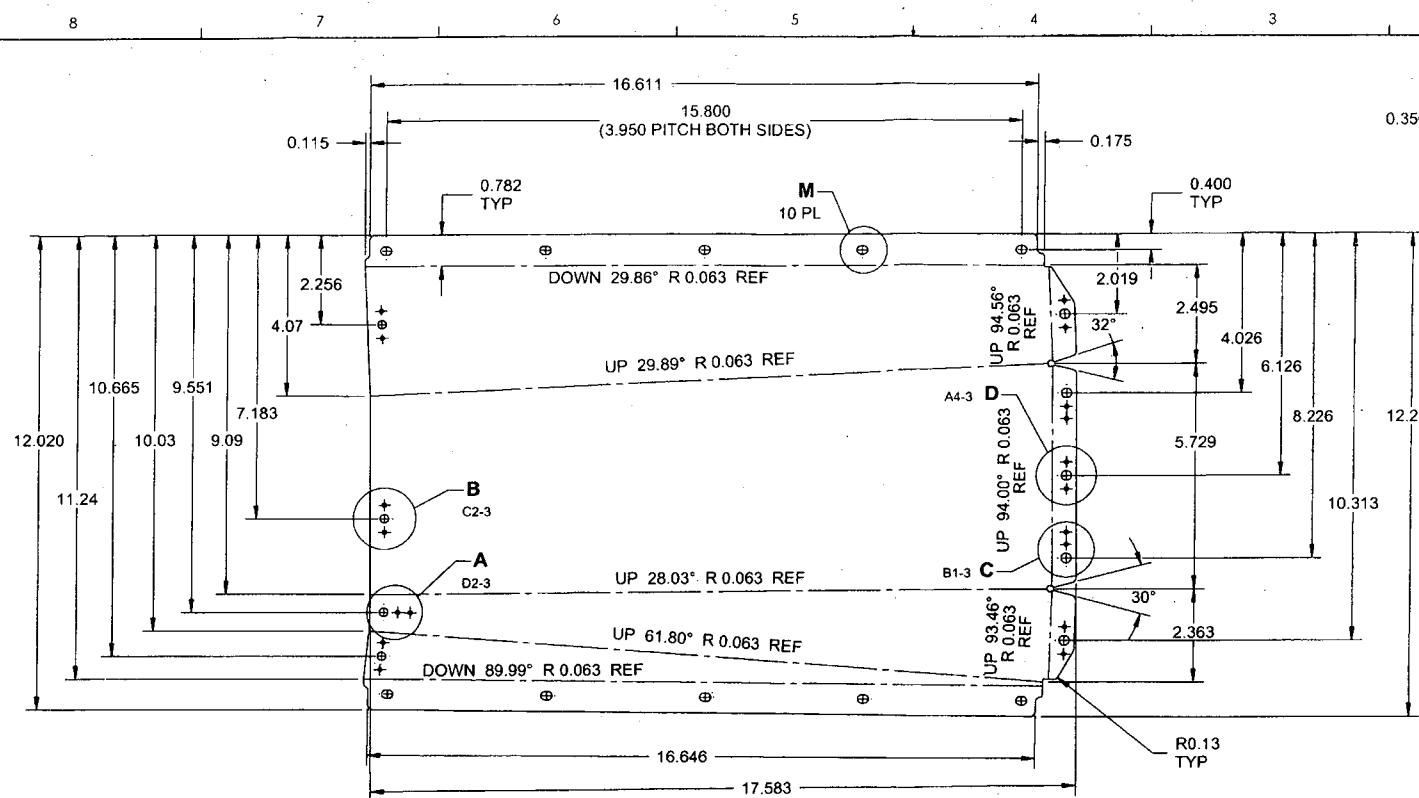
NOTES:
 1) MATERIAL: MAKE FROM D3650-1F
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) IDENTIFICATION: NONE
 6) WEIGHT: 1.3 lbs



D3650-1B AFT PANEL BENT PART

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3650
APPROVED	<i>[Signature]</i>	REV. E
DE APPR.	<i>[Signature]</i>	SHEET 2 OF 8
DATE	12.10.01	TITLE
		TOP PANEL ASSEMBLY
		SCALE
		NTS

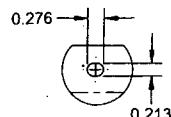
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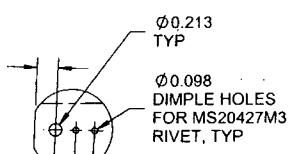
D3650-1F AFT PANEL (FLAT PATTERN)

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET.
 PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
 REF. DART SPEC. M304S26GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.3 lbs

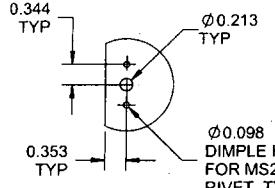
DETAIL M



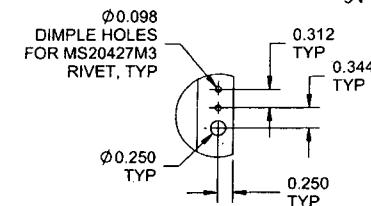
DETAIL D C4-3
3 PL



DETAIL A C7-3



DETAIL B C7-3
3 PL

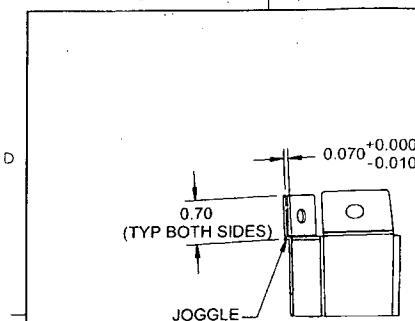
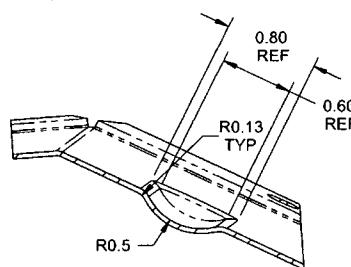
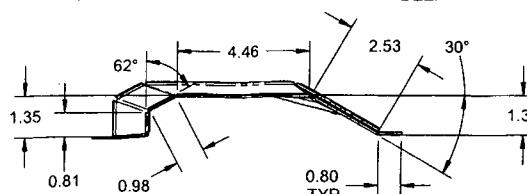
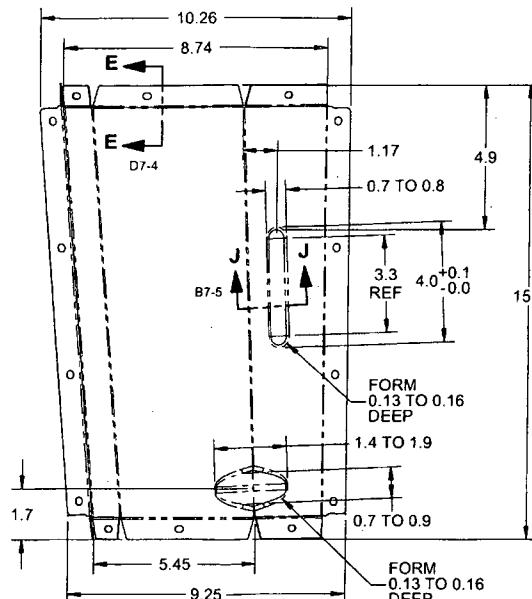
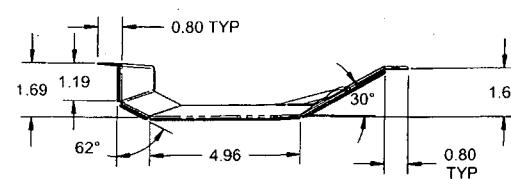
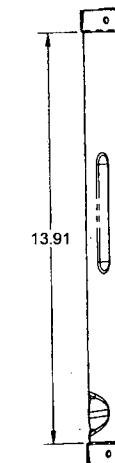
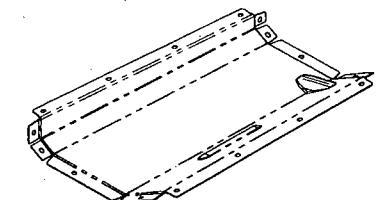


DETAIL C C4-3
2 PL

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3650	
MFG. APPR.		REV. E	SHEET 3 OF 8
APPROVED			
DE APPR.			
DATE	12.10.01	TOP PANEL ASSEMBLY	NTS

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8 7 6 5 4 3 2 1

**SECTION E-E** C5-4**SECTION J-J** C4-4**△ D3650-3 CENTER PANEL**

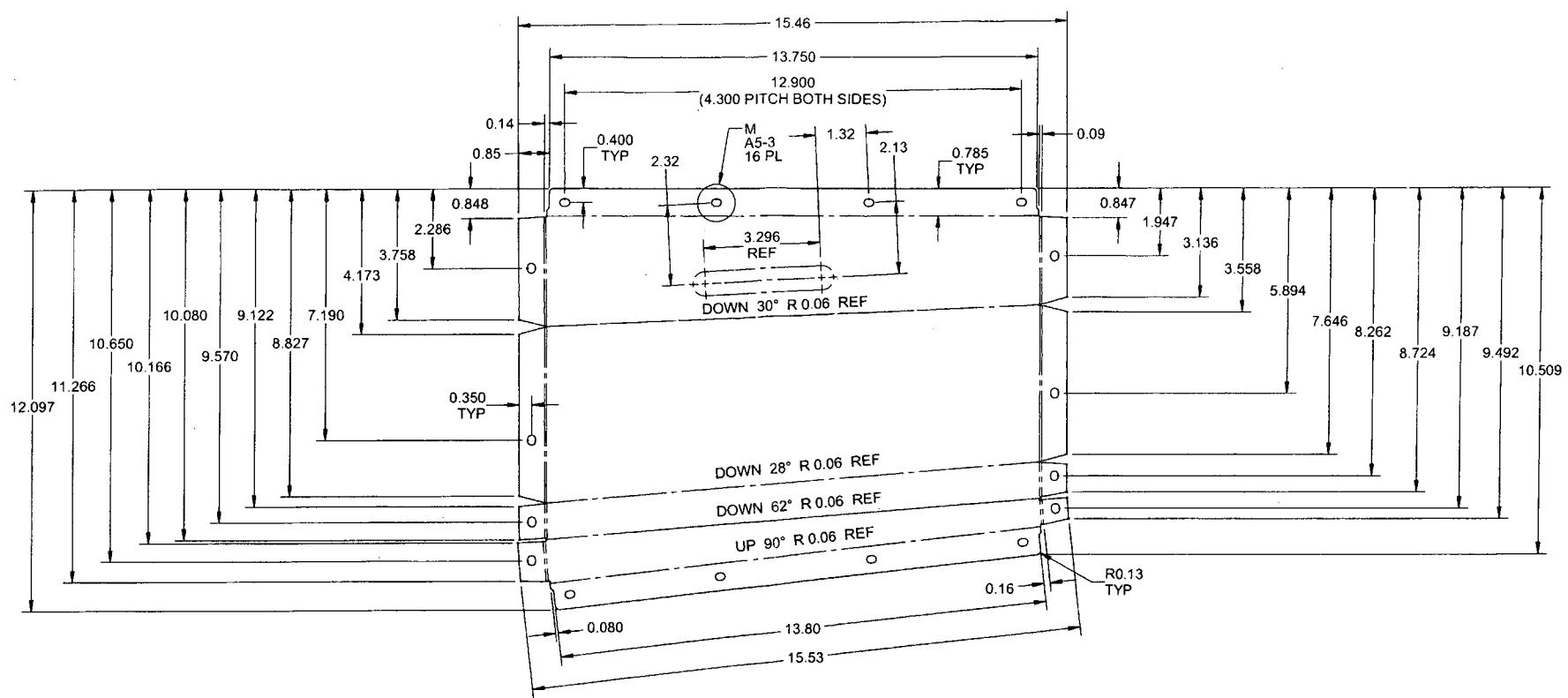
2012-10-05
PAGE 4

NOTES:

- 1) MATERIAL: MAKE FROM D3650-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.98 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. E
MFG. APPR.		SHEET 4 OF 8
APPROVED		
DE APPR.		
DATE	12.10.01	SCALE NTS
		TITLE TOP PANEL ASSEMBLY

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D3650-3F CENTER PANEL (FLAT PATTERN)

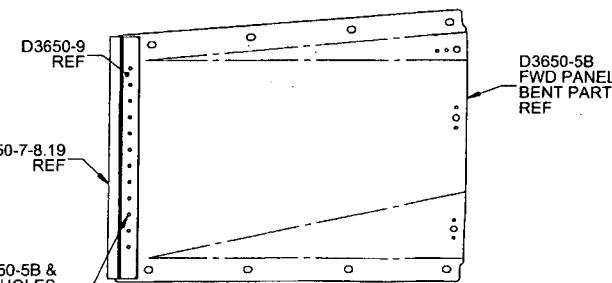
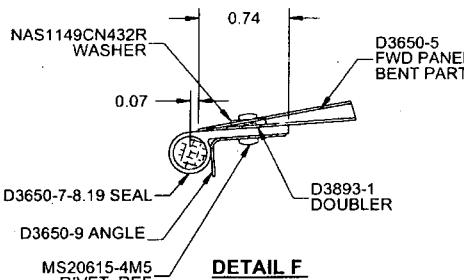
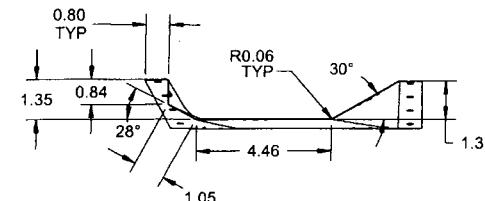
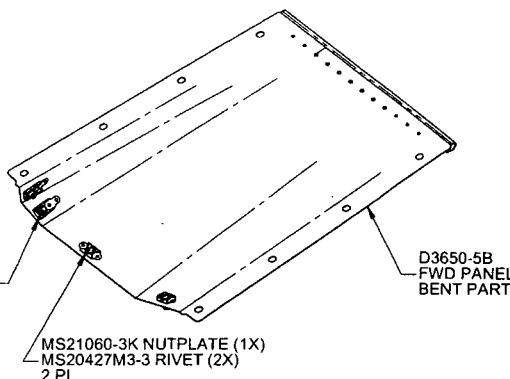
RELEASED
2012-10-09
NN

A NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.040 THICK (20 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.98 lbs

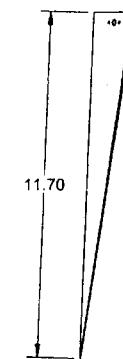
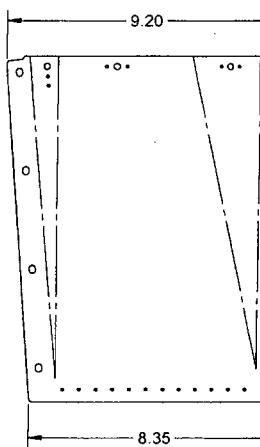
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED			REV. E
MFG. APPR.			SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
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QTY	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
1	D3893-1	DOUBLER
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE



CENTRE D3650-7-9 ON D3650-5B &
TRANSFER Ø0.129 HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
MS20615-4M5 RIVET
NAS1149CN432R WASHER
12 PL

D3650-5 FWD PANEL

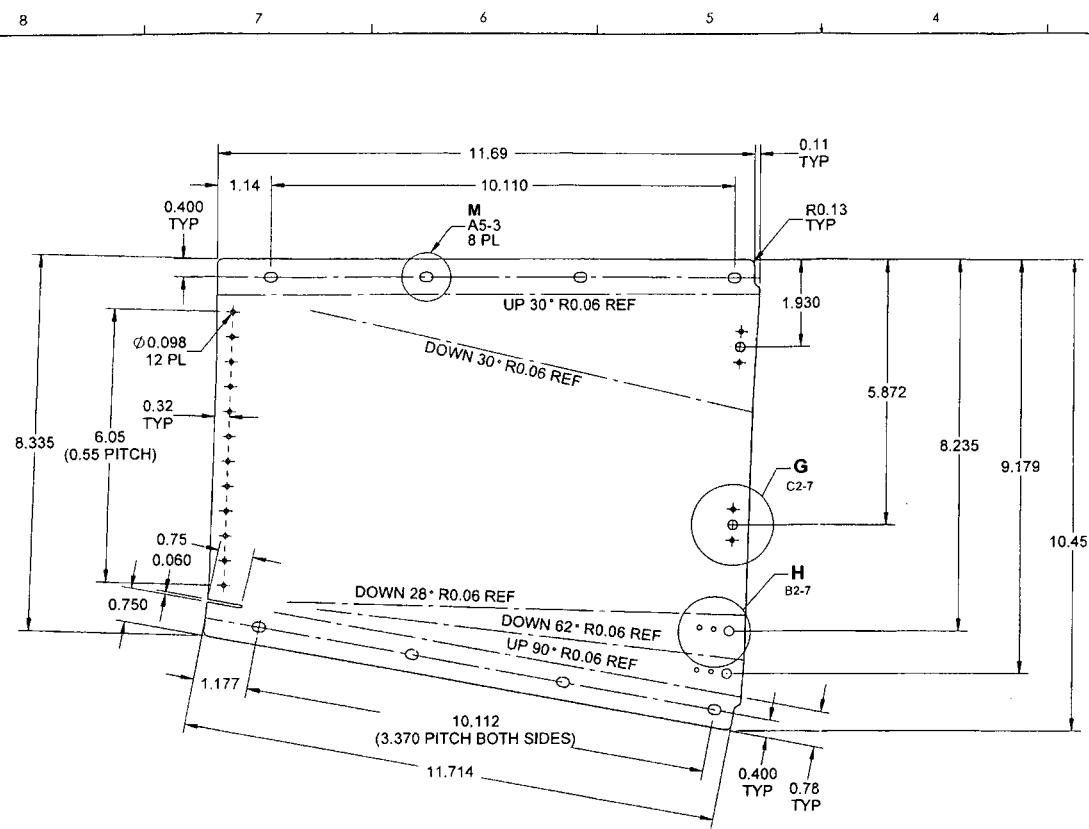


D3650-5B FWD PANEL BENT PART

RELEASED
2012-10-09
[Signature]

- NOTES:
- 1) MATERIAL: MAKE FROM D3650-5F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.8 lbs

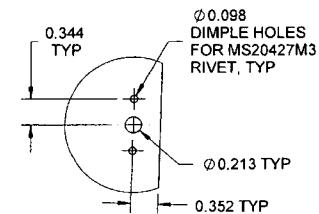
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RR	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3650 REV. E	
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 8	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOP PANEL ASSEMBLY	NTS
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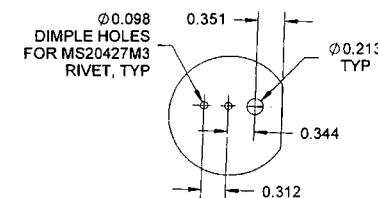
D3650-5F FWD PANEL (FLAT PATTERN)

RELEASE
2012-10-09
AND

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S26GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.6 lb



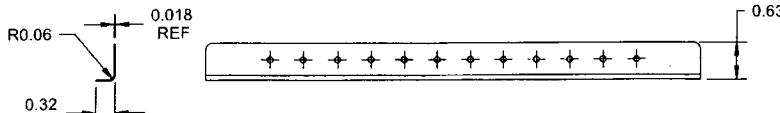
DETAIL G C5-7
2 PL



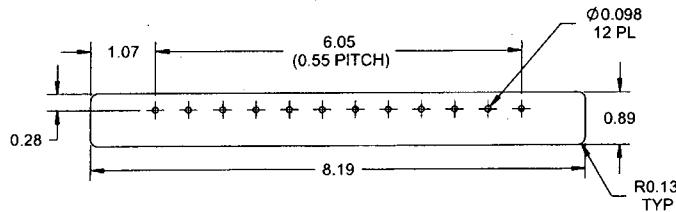
DETAIL H B5-7
2 PL

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SJ	DRAWING NO.	
MFG. APPR.	AP	REV. E	D3650
APPROVED	MF	SHEET 7 OF 8	
DE APPR.	MF	TITLE	TOP PANEL ASSEMBLY
DATE	12.10.01	SCALE	NTS

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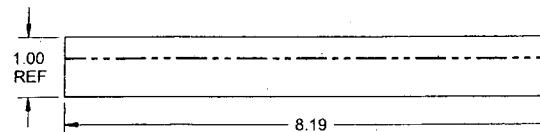
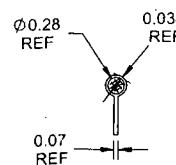


D3650-9 ANGLE
(MAKE FROM D3650-9F)



D3650-9F ANGLE (FLAT PATTERN)

D3650-9F
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S26GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.05 lb



D3650-7-8.19 SEAL

NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

RELEASED
2012-10-09

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. E	
MFG. APPR.		D3650	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.	#	TOP PANEL ASSEMBLY	NTS
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